



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT400325
Job Sheet 189091



Part No: RBT400325

Job Qty: 12 pcs

Part Name: Tail Boom Nut Socket (407)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/18/19

Job Tracking No:

Due Date: 2/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT400325 Rev B IPP Rev A 17.12.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Conventional Lathe - 1	12 pcs		2/15/19	0.00	3.00	Conventional Lathe - 1		
							Conventional Lathe - 2		
120	QC 2	12 pcs		2/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



Dart Aerospace Ltd.
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CANADA

Container No: S152572



Part: RBT400325

Job No: 189091

Serial No/Batch: S152572

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 02/11/19

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130 QC 8	12 pcs	2/15/19	0.00 0.00	QC 2 - 8	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	b.e 19-02-11
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
131 Handfinish -7-1-BeadBlast-B4B	12 pcs	2/15/19	0.00 1.20	Handfinish - 7 - 1 - B4B	BEB 19-02-12
132 Outsource - 12 - Black Oxide	12 pcs	2/15/19		GRO002-VC 10	CT 19-02-14
133 Packaging 2-1 - Receive - B4B	12 pcs	2/15/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 -	

				B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
134	QC 6	12 pcs	2/15/19	0.00 0.00	QC 6 - 38
					QC 6 - 42
					QC 6 - 9
					QC 6 - 68
					QC 6 - 61
140	Packaging 3-1 - Stock - B4B	12 pcs	2/15/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B

DAS
FEB 26 2019 58
9-89

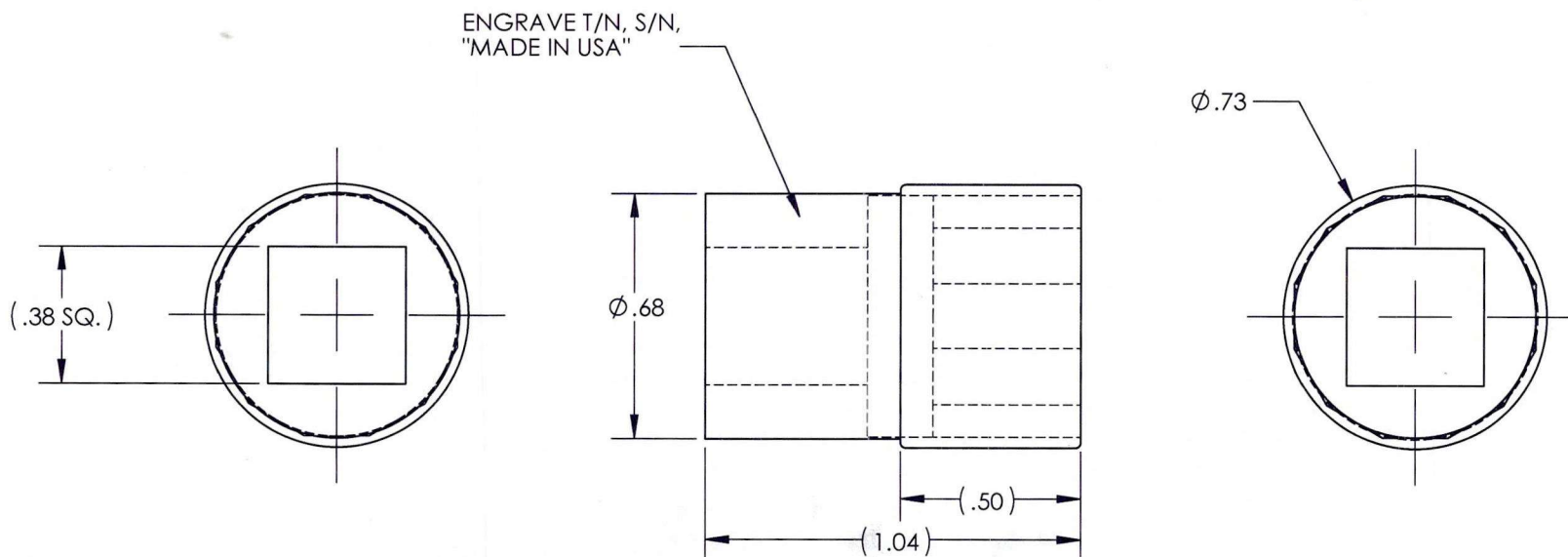
DAS
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9-89

				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS 21 3-25
150 QC 21 - SA	12 pcs	2/15/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
Part Op 110 - (Manufacture as per dwg) 1-Machine as per DWG. DWG REV: _____ Remove all factory markings 2-Descriptions: Deburr 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG. 131 - (Bead Blast) Bead blast, remove remaining chrome 132 - -Issue P/O to Groupe Altech; PO <u>042612</u> -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required 133 - (Receive & Inspect for Damage & Mat'l Certs) 134 - (QC6- All purchased or subcontracted products) 140 - (Identify as per dwg & Stock Location: _____) Bag and tag (T/N and revision number) 150 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
FM14	Socket Tail Boom Nut	12 pcs (1 ea)	110-Conventional Lathe - 1	5044598(3x) 5151525(9x)	GA 033
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Conventional Lathe - 1	FM14	12	3	0	
Part Specifications					
Specifications could not be found.					

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CH'D BUYOUT SOCKET FROM SNAP-ON #FM17.	2/17/2012	RJC	RW
B	DIM WAS .59 IS (.500) DIM WAS 1.04 IS (1.04).	1/3/2013	BIM	GE



NOTE:
1. ORIGINAL BELL #407-230-001-101.
2. REMOVE ALL FACTORY MARKINGS.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189091 NLS
19-01-18

RED BARN MACHINE	
SOCKET TAIL BOOM NUT	
DWG NO. RBT400325	REV B
DRAWN BY: CLOUGH	
APPROVED D Weil	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005 FRACTIONS ± 1/32	
.XX ± .01 ANGLES ± 5°	
.X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45°	
OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL 407	
SCALE 2:1	DATE 10/12/2011
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	SOCKET TAIL BOOM NUT		3/8 DR. 14MM, 12PT. SNAP-ON #FM14 (NEEDS MODIFIED)	



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PURCHASE ORDER

PO042612



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042612
PO Date: 2/14/19
Due Date: 2/22/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189091	RBT400325	Tail Boom Nut Socket (407) -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	2/22/19	12 pcs	0 pcs	12 pcs	\$2.1136363/pcs	\$25.36
2	189453	RBT18560-9	Cross Bar -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	2/22/19	21 pcs	0 pcs	21 pcs	\$2.1136363/pcs	\$44.39
3	189252	RBE350A93-3312-03-1	Receiver (Outside Processing - Black Oxide) -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	2/22/19	15 pcs	0 pcs	15 pcs	\$3.35/pcs	\$50.25



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PURCHASE ORDER

PO042612



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Grand Total:											\$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

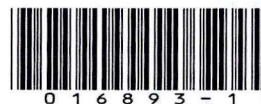
A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 2/15/19 1:15 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

016893- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
21-Feb-2019		SPARTAKOS BOUNTOURIS		042612 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBT400325 ✓ Rev.	RBT400325 01 -OXIDE BLACK [OXIDE BLACK MIL-C-13924C CLASS 1	OXIDE-BLACK CH	12	12 ✓	0	0	0
2	RBT18560-9 ✓ Rev.	RBT18560-9 BLACK OXIDE FINISH MIL-C-13924C CLASS 1	OXIDE-BLACK CH	21	21 ✓	0	0	0
3	RBE350A93-3312-03-1 ✓ Rev.	RBE350A93-3312-03-1 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OILMIL-PRF-16173 GRADE 3 CLASS 1	BLACK-OXIDE CH	15	15 ✓	0	0	0

You already have at shop

42649

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

SM

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.